

NCP-19-7642



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RBW109-3101-14-1-01

Job Sheet 199528



Part No: RBW109-3101-14-1-01

Job Qty: 2 pcs

Part Name: Frame Top



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/14/19

Description:

Type: SOLD

Note: DWG RBW109-3101-14-1 Rev 2 IPP Rev. A 19.08.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	2 pcs		10/14/19	0.17	0.40	Waterjet - Omax		ac 19/10/02
110	QC 2	2 pcs		10/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		ac 19/10/01
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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3/27/19

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Conventional Mill - 1 - B4B	2 pcs	10/14/19	0.00 1.00	Conventional Mill - 1 - B4B	
					Conventional Mill - 2 - B4B	
130	QC 2	2 pcs	10/14/19	0.00 0.00	QC 2 - 1	ALA / 3 c.v. 19-10
					QC 2 - 12	
					QC 2 - 14	ALA / 3 c.v. 19-10
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	2 pcs	10/14/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.e 19-10-08

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				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150	Outsource - 4 - Anodize	2 pcs	10/14/19		
				GR0002-VC	08 oct 2019 PL
160	Packaging 2-1 - Receive - B4B	2 pcs	10/14/19	0.00 0.00	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170	QC 6	2 pcs	10/14/19	0.00 0.00	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
					OCT 2 4 2019 DAS 10 8-89
180	Packaging 3-1 - Stock - B4B	2 pcs	10/14/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
					DAS 28 8-89

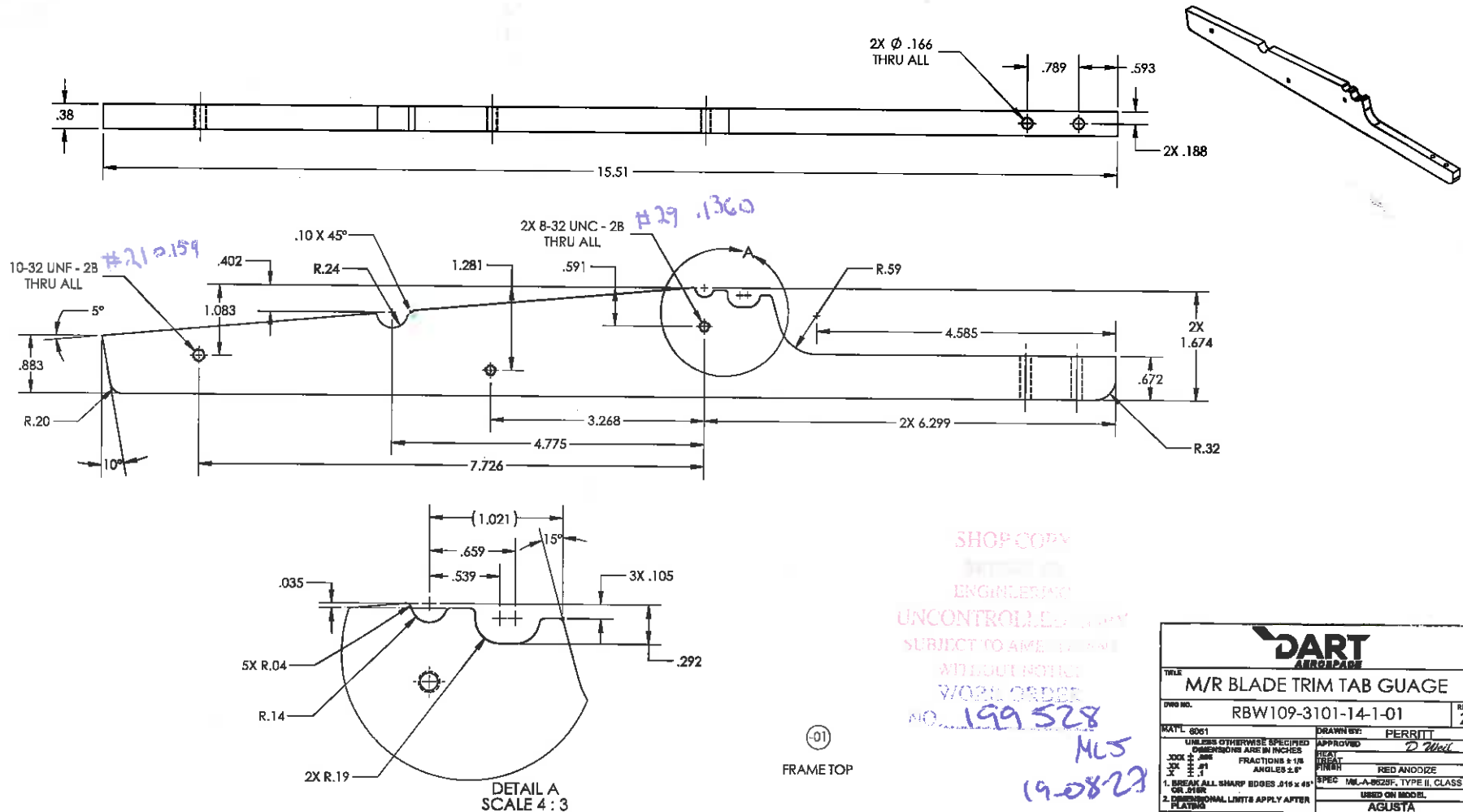
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	2	10/14/19	0.00 0.00	QC 21 - SA - 21	MAO
	pcs			QC 21 - SA - 70	21 OCT 25 2019
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>2</u> PROG. Rev: <u>2</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - 1-Machine as per DWG. 2-Deburr 130 - QC2- Inspect parts off machine FAI/FAIB 140 - QC8- Inspect parts - second check 150 - -Issue P/O; _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant - Material type; 6061T6 -Certificate of Conformity is required 160 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required 170 - QC6- All purchased or subcontracted products 180 - Identify as per dwg & Stock Location: _____ 190 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.375	6061T6 Sheet, .375	.3620 sf (.181 ea)	100-Waterjet - Omax - 1	5187865	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	M6061T6S.375	0	20	0	
Part Specifications					
Specifications could not be found.					

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DXF

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REVISIONS								
REV	ECR	DESCRIPTION				DATE	INITIAL	APPROVED
1		-01 CHD DIMS WAS .409 IS .402, WAS 4.849 IS 4.775, CHD FINISH WAS POWDER COAT FORREST 1-5920 BY YELLOW RIBBON MIL-P-88348 IS POWDER COAT YELLOW FED #13538.				2/13/14	DPD	GE
2	15-0117	-01 ADDED .10 X 45° CHAMFER, CHD FINISH WAS POWDER COAT YELLOW FED #13538 IS RED ANODIZE.				5/29/2015	RJC	JAG



DART AEROSPACE	
TITLE: M/R BLADE TRIM TAB GAUGE	
DWG NO.: RBW109-3101-14-1-01	REV: 2
MAT'L: 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D. Mott</i>
3X .005	FRACTIONS ± 1/8
2X .01	ANGLES ± 5°
1X .1	RED ANODIZE
OR .018	SPEC MIL-A-8829F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x .015	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE: 2:3	DATE: 3/8/2010
SHEET 2 OF 13	



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Container No: S219098



Part: RBW109-3101-14-1-01

Job No: 199528

Serial No/Batch: S219098

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 10/02/19

Entered: JK Date: Oct 28/19



NCR No. 19-7642 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>199528</u> Part No. <u>RBW1093101-14-1-01</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier Quality ☐			
Date: <u>19-10-05</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u> <u>5</u>		MRR (QSI042) DAS 9 9-89 1 2019	
Description Work Order Deviation				Disposition			
→ 1 part has a section of (.046" high) by (.0625 wide) in between .591" dimension and 8-32 hole so dimension (1.674 +/- .005") is 1.630 → Defect on part was found at Qc8				→ Scrap and destroy → No replace			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled				FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
Other/Details:							